

Date: Thursday, 9/20/2007 3:23:39 PM
 User: Kim Johnston

Process Sheet

41

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (13"X16")
Job Number	: 34724		
Estimate Number	: 10317		
P.O. Number	:	Part Number	: D206559021
This Issue	: 9/20/2007 S.O. No. :	Drawing Number	: D2671 REV B1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	: 28342	Material	:
Written By	:	Due Date	: 10/10/2007 Qty: 4 Um: Each
Checked & Approved By	: <u>JA 07.09.20</u>		
Comment	: Est Rev:C 04.02.17 Blank size changed KJ/JLM Est Rev:D 07-01-02 Was K10005 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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④

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-559-021 CHG006

JL 08/02/07

RS 07.09.21

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 2.9444 sf(s)/Unit Total : 11.7776 sf(s)
 blank: 13.25" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-1
 Material: Black UHMW 1"
 (MUHMWB10)
 Batch: M106161

JL 08/01/27

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2671 Identify as D2671

3-Deburr

JL 08/01/27

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 08/01/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/20/2007 3:23:39 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (13"X16")

Job Number: 34724

Part Number: D206559021

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8F 08/01/28 (F)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 1.6700 f(s)/Unit Total : 6.6800 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B050 Rubber Cushion 34777

8.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block 35205 (28X) 32857 (4X)
2 D2671(ref only) Bearpaw 34724

9.0

D2438

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2438 Clamp B36508

10.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer A10 B35356

LC 8/02/01 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/20/2007 3:23:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (13"X16")

Job Number: 34724

Part Number: D206559021

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A

Bolt

M106375

12.0

AN417A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-17A

Bolt

M10691

13.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

M106780

14.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M105938

15.0

QS200M44S

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 QS200M44S

Clamp

M106074 1X

1 Paperwork package

QS200 44S M106286 6X

W same M105572 1X

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/02/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/20/2007 3:23:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (13"X16")

Job Number: 34724

Part Number: D206559021

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/02/07 (4)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-021

Location: *Draft*

8/21/07

50 (4X)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/02/07

Job Completion



2008/12/04 (4)

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34724
Description: Bearpaw		Part Number:	D2671
Inspection Dwg: D2671 Rev: B1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.07x45°	✓			
B	5.500	+/-0.030	5.500	✓			
C	0.200	+/-0.030	.203	✓			
D	R0.250	+/-0.030	0.250	✓			
E	0.625	+/-0.030	.624	✓			
F	0.250	+/-0.010	.250	✓			
G	0.950	+0.030/-0.010	.953	✓			
H	0.25 x 45°	+/-0.030	.25x45°	✓			
I	0.375	+/-0.010	.380	✓			
J	12.750	+/-0.030	12.750-	✓			
K	Ø0.260	+0.005/-0.000	.260	✓			
L	Ø0.93	+/-0.030	.930	✓			
M	0.30	+0.030/-0.000	.315	✓			
N	4.250	+/-0.030	4.250	✓			
O	0.375	+/-0.030	.375	✓			
P	2.000	+/-0.030	2.000	✓			
Q	4.250	+/-0.010	4.250	✓			
R	9.000	+/-0.010	9.000	✓			
S	15.750	+/-0.030	15.750	✓			

Measured by:	J.L	Audited by:	SA	Prototype Approval:	N/A
Date:	08/01/26	Date:	08/01/26	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	★

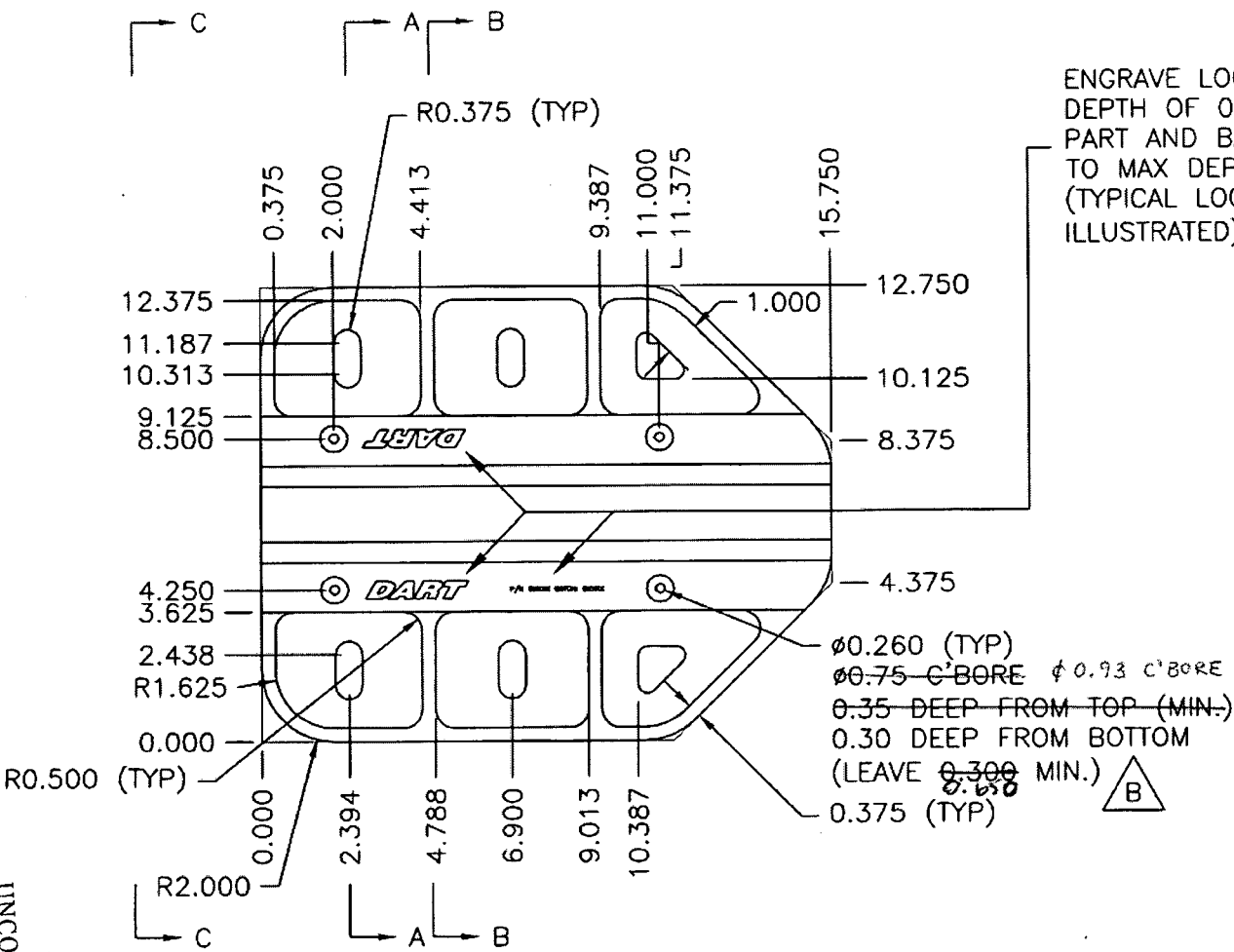


DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2671	REV. B
DATE 98.05.19		TITLE BEARPAW	SHEET 1 OF 2
			SCALE 1:5
A	97.04.08	NEW ISSUE	
B	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

RELEASED
98.06.17 KE

EFFECTIVE	DEOS
9/43	

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

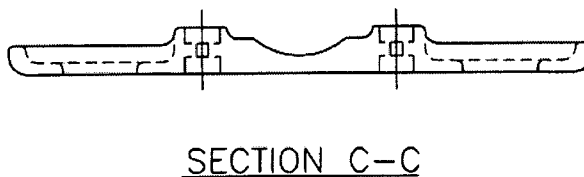
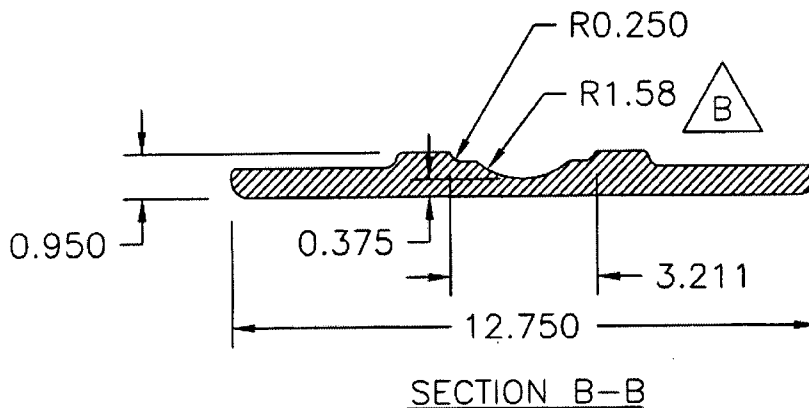
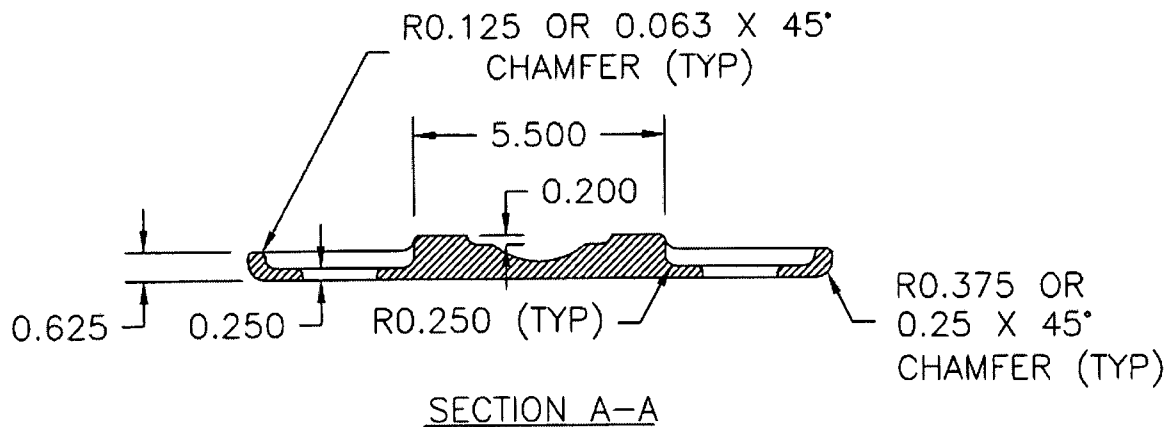
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WORK ORDER NO. 34724

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WITHOUT NOTICE



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2671	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 *KE*



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WITHOUT NOTICE
WORK ORDER
NO. 34724

Date: Thursday, 01/05/2008 2:01:17 PM
 User: Melanie Fauteux

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D206559021
Job Number : 38955	
Estimate Number : 10804	
P.O. Number :	Part Number : ECN30
This Issue : 01/05/2008 S.O. No. :	Drawing Number : ECN1022
Prsht Rev. : NC	Project Number :
First Issue : / / Type : MACHINED PARTS	Drawing Revision :
Previous Run : 38954	Material :
Written By : <u>mf</u>	Due Date : 01/05/2008 Qty: 1 Um: Each
Checked & Approved By : <u>mf</u>	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

UPDATE PAPERWORK:

D206559021

B

28342

B

34724

ADD IIN+ ICA + MDL TO KITS

PER ECN1022

CHANGE LABELS TO NEW CHANGE NUMBER

CHG007

RETURN TO STOCK

2.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

mf 08-05-05